

Date: Friday, 27/02/2009 10:35:45 AM  
User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: SADDLE, OUTBOARD, LH, 206		
<b>Job Number</b>	: 46097			<b>Part Number</b>	: D26651		
<b>Estimate Number</b>	: 10818			<b>Drawing Number</b>	: D2665 REV.D		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 27/02/2009	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: D		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: //	<b>Type</b>	: MACHINED PARTS			<b>Due Date</b>	: 11/03/2009
<b>Previous Run</b>	: 44282			<b>Qty:</b>	8	<b>Um:</b>	Each
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	: <u>JUL 09.02.27</u>						
<b>Comment</b>	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev:D 07-03-19 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	Saddle Billet, 7075	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length	<u>B31387 X 9 PCS</u> <u>B25396 X 1 PCS</u> <u>B34873-2 X 2 PCS J.F. 09/03/09</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 5- Deburr	<u>J.F.</u> <u>09/03/09</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<u>J.F./DTP 09/03/10</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>J.F./DTP 09/03/10</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 27/02/2009 10:35:46 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 46097

Part Number: D26651

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

A.A 09/03/11

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(7)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BK 09-03-11

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1110939.

(7)

START TIME: 9:25

OVEN TEMPERATURE: 320

FINISH TIME: 9:55

BK 09-02-12

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-03-12

(7)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(7k)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 436

9/3/13

SP

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(7)

Comment: FINAL INSPECTION/W/O RELEASE

D 09/03/16

Job Completion



11 09.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	H6097
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
A	0.100	0.140		.106	.107	.106	.1065			
B	0.100	0.140		.119	.120	.115	.122			
C	1.125	1.145		1.132	1.132	1.131	1.1325			
D	0.615	0.685		.652	.652	.652	.6500			
E	0.240	0.260		.248	.248	.249	.250			
F	1.313	1.343		1.321	1.321	1.321	1.3175			
G	0.210	0.230		.214	.214	.213	.2135			
H	0.100	0.180		.133	.133	.133	.135			
I	2.470	2.510		2.493	2.493	2.493	2.492			
J	1.565	1.585		1.571	1.572	1.570	1.572			
K	0.235	0.240		.238	0.238	0.237	0.237			
L	0.100	0.120		0.119	0.119	0.120	0.111			
M	0.990	1.010		1.008	1.0065	1.0065	1.006			
N	0.510	0.515		.510	0.510	0.510	0.510			
O	5.990	6.010		6.000	6.000	6.000	6.003			
P	1.245	1.255		1.251	1.250	1.250	1.250			
Q	2.495	2.505		2.500	2.500	2.500	2.509			
R	0.313	0.318		.314	0.314	0.314	0.314			
S	0.315	0.322		.316	0.316	0.316	0.316			
T	2.495	2.505		2.499	2.499	2.499	2.496			
U	1.357	1.367		1.363	1.363	1.363	1.362			
V	0.787	0.807		.799	.799	.798	.795			
W	0.540	0.560		.550	.552	.552	.550			
X	1.674	1.684		1.680	1.680	1.682	1.679			
Y	0.257	0.262		.259	0.259	0.259	0.257			
Z	0.912	0.932		.924	.925	.924	.910			
AA	0.490	0.510		.502	0.502	0.504	0.501			
AB	0.178	0.198		R.188	R.188	R.188	R.188			
AC										
AD										
AE										
AF										
Accept/Reject										

Measured by:	J.F.	Audited by:	H.A.
Date:	09/03/09	Date:	09/03/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	JLM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46097
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	4	By	Date
A	0.100	0.140		0.106	0.105	0.107			
B	0.100	0.140		0.120	0.120	0.120			
C	1.125	1.145		1.1305	1.1305	1.1335			
D	0.615	0.685		0.600	0.600	0.600			
E	0.240	0.260		0.249	0.250	0.250			
F	1.313	1.343		1.3175	1.316	1.317			
G	0.210	0.230		0.213	0.212	0.214			
H	0.100	0.180		0.130	0.130	0.130			
I	2.470	2.510		2.490	2.493	2.492			
J	1.565	1.585		1.5695	1.570	1.572			
K	0.235	0.240		0.237	0.2375	0.238			
L	0.100	0.120		0.110	0.112	0.113			
M	0.990	1.010		1.106	1.106	1.1065			
N	0.510	0.515		0.510	0.510	0.510			
O	5.990	6.010		6.003	6.003	6.003			
P	1.245	1.255		1.250	1.250	1.250			
Q	2.495	2.505		2.500	2.500	2.500			
R	0.313	0.318		0.314	0.314	0.314			
S	0.315	0.322		0.316	0.316	0.316			
T	2.495	2.505		2.497	2.497	2.497			
U	1.357	1.367		1.362	1.362	1.362			
V	0.787	0.807		0.794	0.794	0.794			
W	0.540	0.560		0.549	0.548	0.548			
X	1.674	1.684		1.679	1.679	1.679			
Y	0.257	0.262		0.257	0.257	0.257			
Z	0.912	0.932		0.920	0.920	0.920			
AA	0.490	0.510		0.503	0.503	0.504			
AB	0.178	0.198		0.188	0.188	0.188			
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	DJP	Audited by:	KJA
Date:	09/03/10	Date:	09/03/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

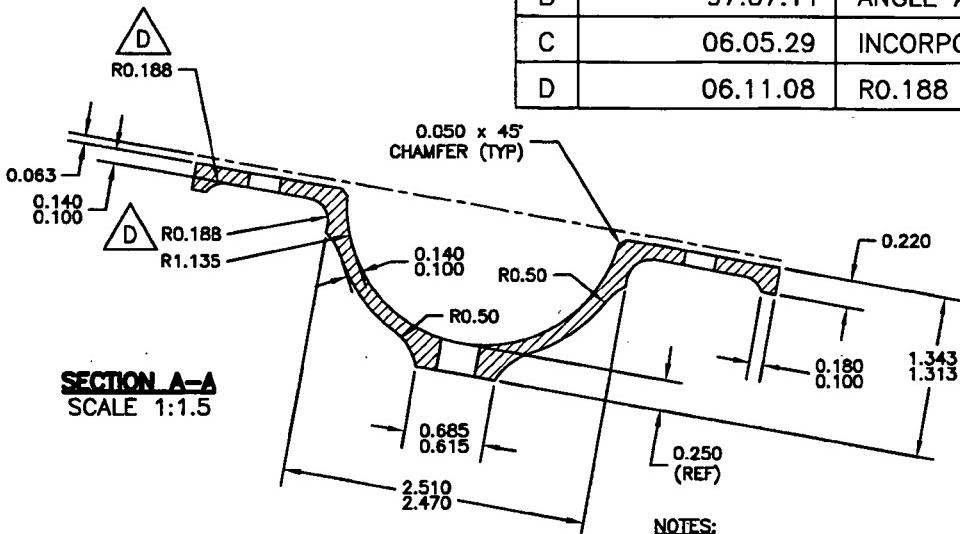
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

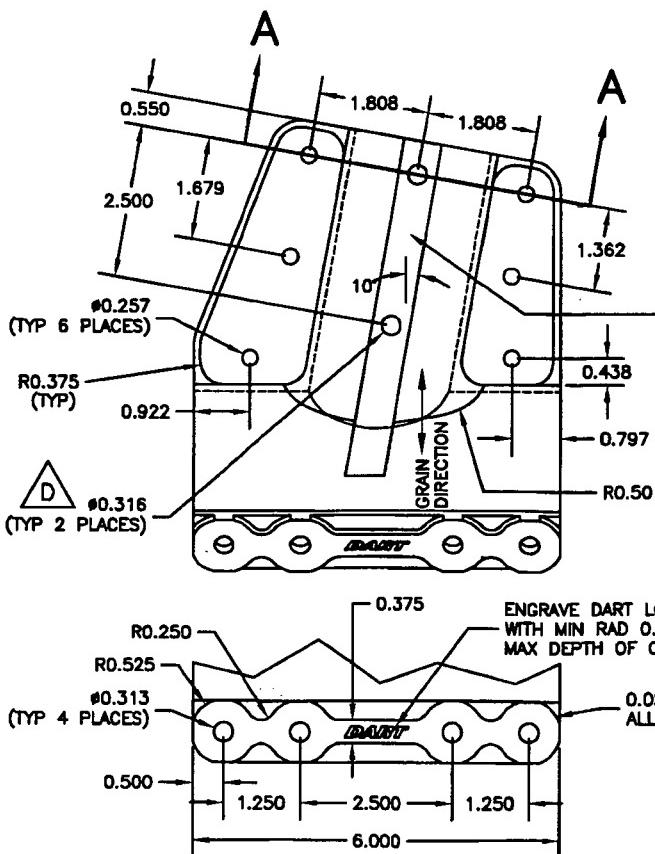
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. D D2665
DATE		SHEET 1 OF 1
06.11.08		TITLE SCALE SADDLE FWD OUTSIDE HIGH 1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313



SECTION A-A  
SCALE 1:1.5

NOTES:

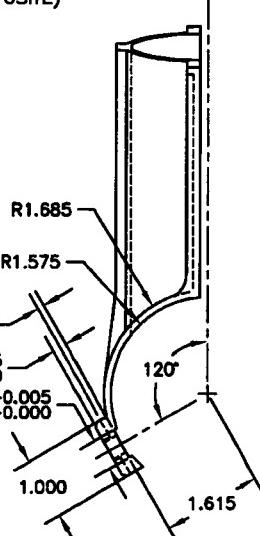
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40001

0.375  
R0.250  
R0.525  
Ø0.313  
(TYP 4 PLACES)  
0.500  
1.250  
2.500  
1.250  
6.000

ENGRAVE DART LOGO TO  
WITH MIN RAD 0.250  
MAX DEPTH OF 0.015  
0.050 X 45° CHAMFER  
ALL AROUND



**D2665-1 SADDLE FWD OUTSIDE HIGH**

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries